

# Work Order ID 75832

**\*75832\***

Page 1

November-01-11 8:22:57 AM

Item ID: D3272-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step  
 Start Date: 01/11/2011 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 02/11/2011 Req'd Qty: 8.00 **\*8\*** Customer:  
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/01 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3272	Rev B								

100 Large Fab 0.00  
**\*100\***  
 Large Fab Memo 0.00  
 Large Fab \*\*\*SQUARE ONE END BEFORE CUTTING OTHER END\*\*\*

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A  
 2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.  
 3-Deburr

110 QC6- Inspect dimensions to drawing 0.00  
**\*110\***  
 QC Memo 0.00  
 Quality Control

*Handwritten signature* 8 *Handwritten symbol*

*Handwritten signature* 8x *Handwritten symbol*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

November-01-11 8:22:57 AM

**Item ID:** D3272-1

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Revision ID:

Item Name:	Step
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Stop \*NS2\*

**Start Date:** 01/11/2011 **Start Qty:** 8.00

**\*8\***

**Cust Item ID:**

**Required Date:** 02/11/2011      **Req'd Qty:** 8.00

\*8\*

**Customer:**

**Reference:**

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation	Description
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100	...

### Set Up/ Run Hours

**Tool ID**

**Tool #**Plan  
Code

Accept  
Qty

Reject  
Qty

**Reject  
Number**

**Insp.  
Stamp**

120

Identify as per dwg & Stock Location: W4

0.00

**\*120\***

## Packaging

## Memo

0.00

## Packaging

12.11.01

130

QC21- Final Inspection - Work Order Release

0.00


**\*130\***

QC

## Memo

0.00

## Quality Control

11/11/02   
me  
11-11-01

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NOTE: Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 75832

**\*75832\***

Parent Item: D3272-1

**\*D3272-1\***

Parent Item Name: Step

Start Date: 01/11/2011

Required Date: 02/11/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-06-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2622-120C

Manufactured

No

100

Each

66.0200

1

8

**\*D2622-120C\***

**\*\***

*11.11.01*

Step Extrusion

Location

Loc Qty

Loc Code

HALL

56.32

64409

6

68293

0.5

72131

49.82

WA

9.7

46910

2

66970

7.7

8

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>qp</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *ff*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET



**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. *25832* *M.C.U*  
*11/11/01*

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

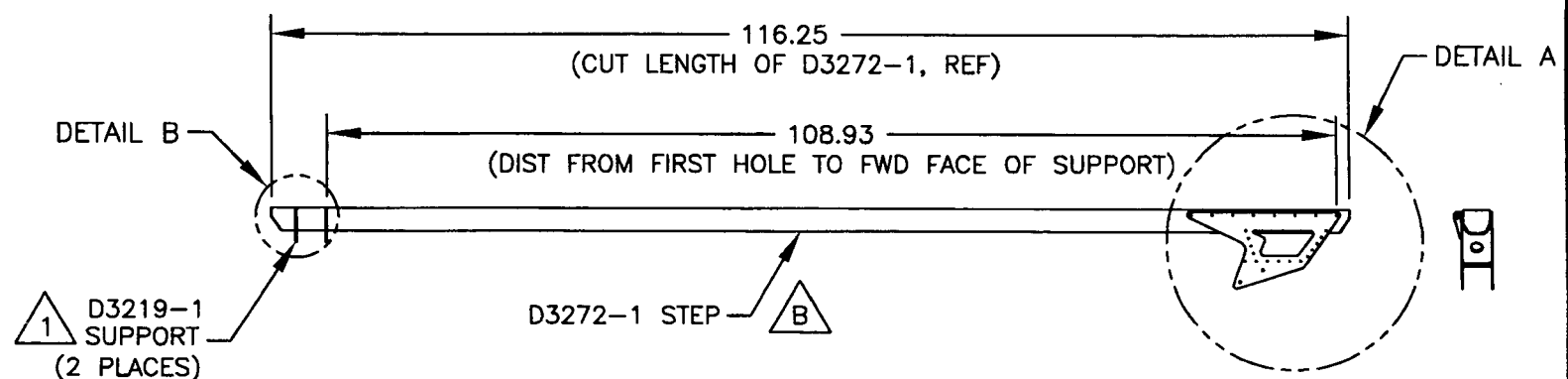
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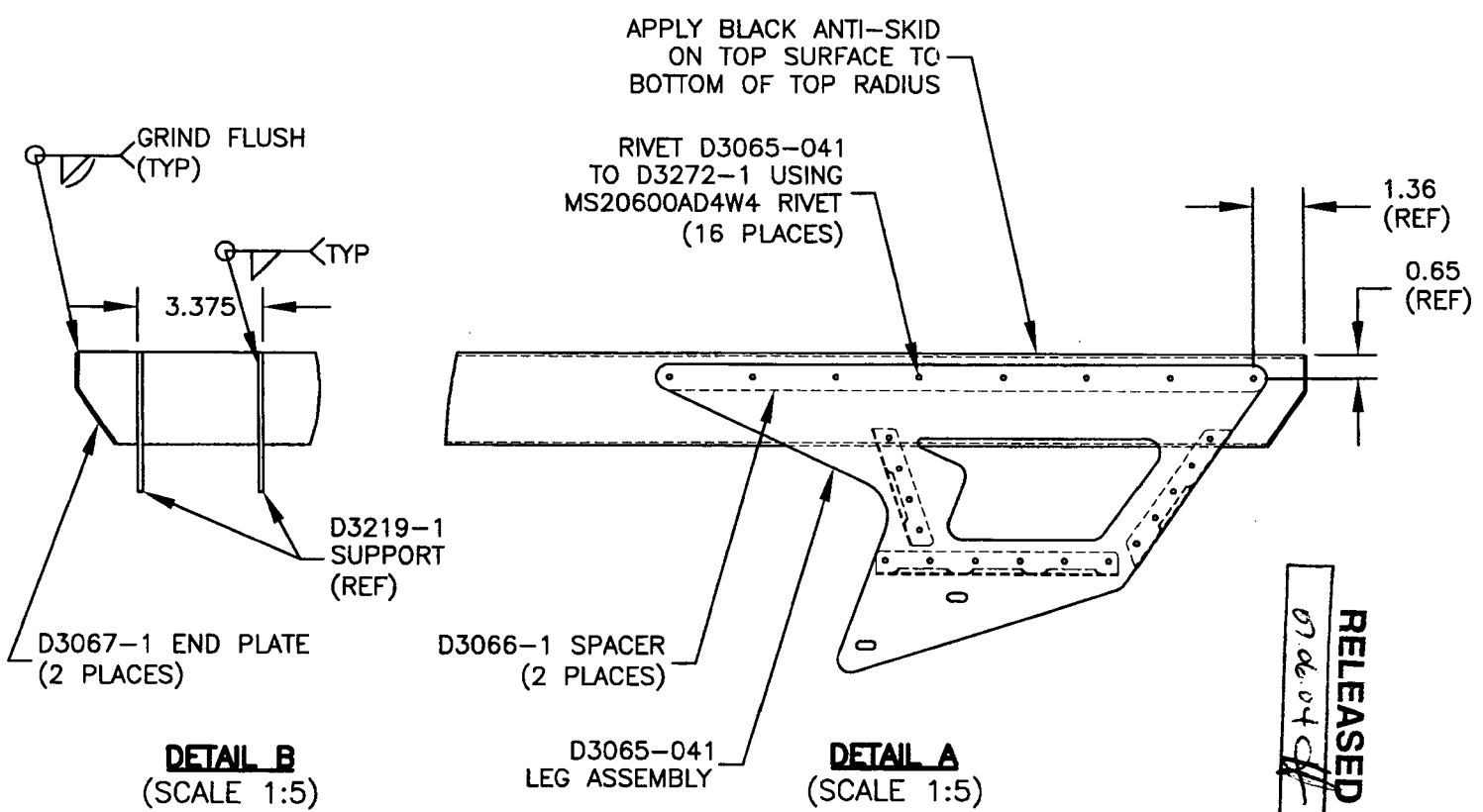
NOTE: Date & initial all entries



75832



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
**D3272-042 STEP ASSEMBLY (RH, OPPOSITE)**



DESIGN	q	DRAWN BY	q	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED	[Signature]	REV. B
DATE	07.05.18	DRAWING NO.	D3272	SHEET 2 OF 3
		TITLE	STEP ASSEMBLY, HI LONG	SCALE
				1:20

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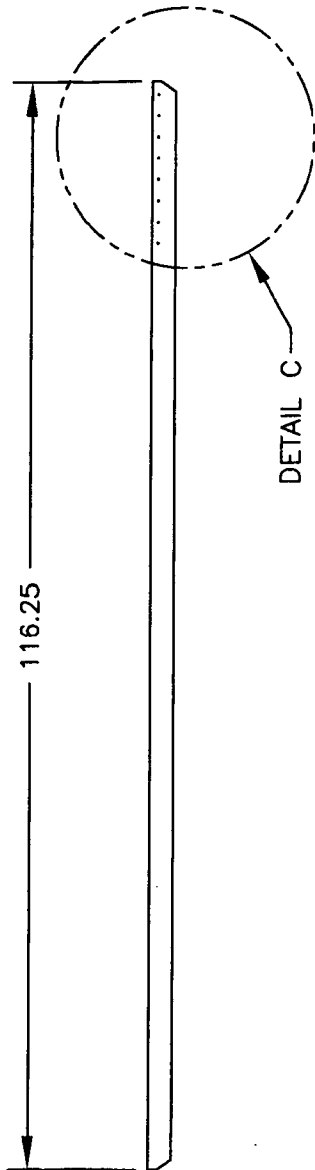
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 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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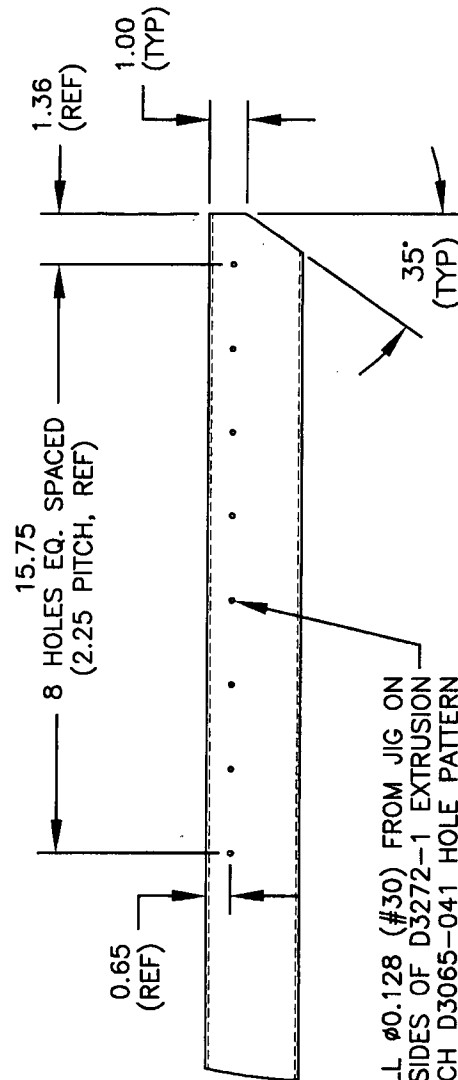


DESIGN <i>qp</i>	DRAWN BY <i>js</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



DETAIL C

**B** D3272-1 STEP  
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL  $\phi 0.128$  (#30) FROM JIG ON  
BOTH SIDES OF D3272-1 EXTRUSION  
TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

RELEASED

07.06.04 *[Signature]*

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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